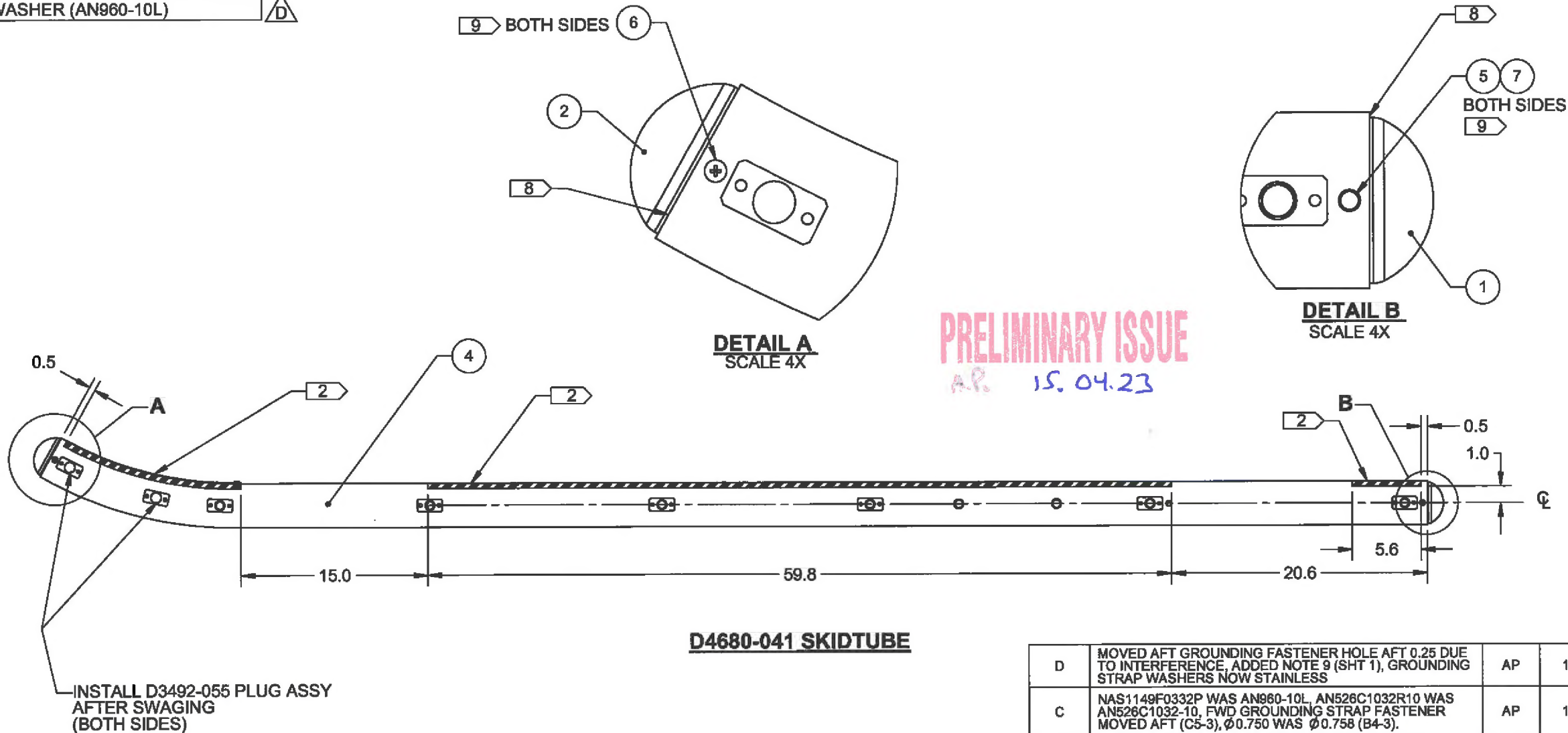


ITEM	QTY -041	P/N	DESCRIPTION
	X	D4680-041	SKIDTUBE
1	1	D2965	CAP
2	1	D2965-3	CAP
3	4	D3492-055	PLUG ASSY
4	1	D4680-043	SKIDTUBE SUB ASSY
5	2	AN3C5A	BOLT
6	2	AN526C1032R10	SCREW
7	2	NAS1149C0332R	WASHER (AN960-10L)

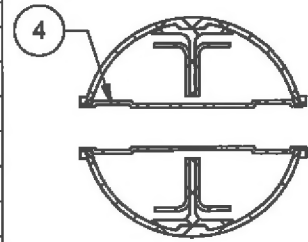


D4680-041 SKIDTUBE

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 1.00 ABOVE CENTERLINE PER QSI 005 SECTION 4.4
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4680-041" AND B/N PER QSI 044 METHOD 6.4 ON INNER RADIUS OF SKIDTUBE BEFORE INSTALLING D2965 CAP
  - 7) WEIGHT: 18.56 lbs
  - 8) SEAL FAYING SURFACES WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B-2 SEALANT
  - 9) INSTALL FASTENERS WET WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B-2 SEALANT

D	MOVED AFT GROUNDING FASTENER HOLE AFT 0.25 DUE TO INTERFERENCE, ADDED NOTE 9 (SHT 1), GROUNDING STRAP WASHERS NOW STAINLESS	AP	15.03.04
C	NAS1149F0332P WAS AN960-10L, AN526C1032R10 WAS AN526C1032-10, FWD GROUNDING STRAP FASTENER MOVED AFT (C5-3), Ø0.750 WAS Ø0.758 (B4-3).	AP	14.07.29
B	FWD CAP WAS D2965, NOW D2965-3, VARIOUS DIMENSIONAL CHANGES. D3492-055 PLUG ASSY WAS D3492-051, SWAGING DIMENSION NOW 0.650 WAS 0.661 (D6-2), ADDED DETAIL H (C2-3), MATERIAL D2962-150 WAS D2962-131 (A7-3), GROUND HANDLING THRU HOLES NOW WELDED, ADDED SECTION G-G (D3-2)	AP	13.09.10
A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	<b>DART AEROSPACE USA, INC.</b> KENT, WA DRAWING NO. <b>D4680</b> REV. D SHEET 1 OF 3 TITLE <b>SKIDTUBE</b> SCALE <b>NTS</b>	
DRAWN	AP		
CHECKED	DW		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	DS		
DATE	15.03.04	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

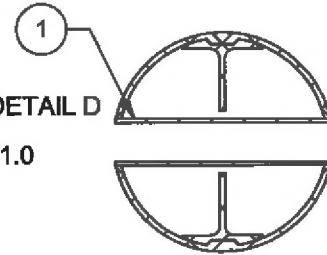
ITEM	QTY	P/N	DESCRIPTION
	X	D4680-043	SKIDTUBE SUB ASSY
1	2	D2973	SPACER
2	1	D4680-1	SKIDTUBE
3	1	D4681-041	WEB ASSY
4	8	D4686-1	SPACER
5	16	D4753-1	DOUBLER
6	3	AELS-1032-130	INSERT
7	3	AN3C4A	BOLT
8	32	MS20601AD4W3	RIVET, BLIND, CSK
9	3	NAS1149C0332R	WASHER (AN960-10L)



**SECTION C-C** 10  
SCALE 4X  
8 PL

INSTALL D4686-1 SPACER AS FOLLOWS (8 PL)  
AFTER INSTALLING D4753-1 DOUBLERS PER DETAIL D

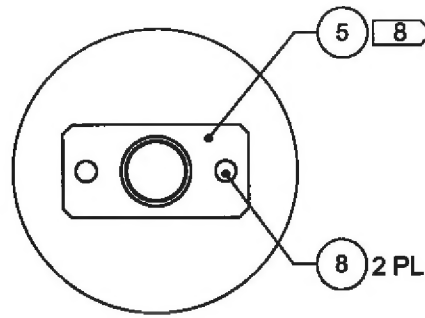
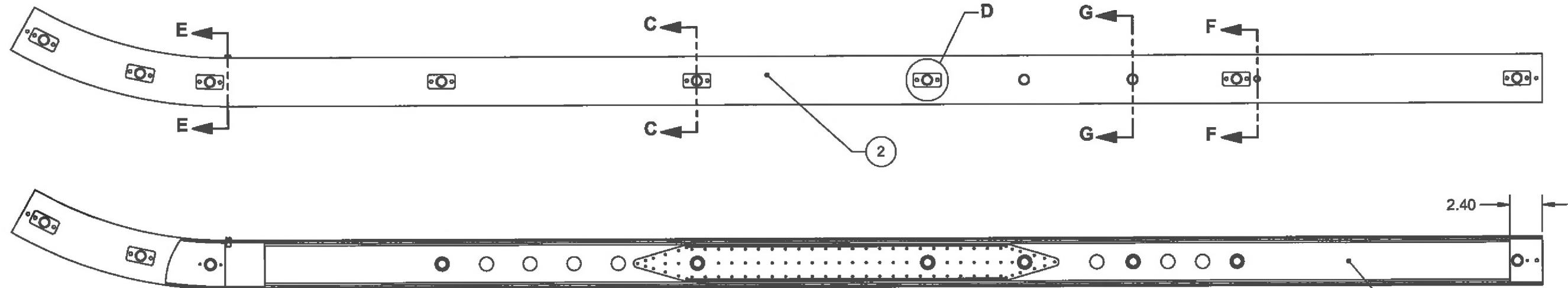
1. INSERT D4686-1 SPACER
2. SWAGE TO  $\varnothing 0.650 +0.010/-0.000$  X 1.0
3. TRIM/GRIND FLUSH PER QSI 002



**SECTION G-G** 11  
SCALE 4X  
2 PL

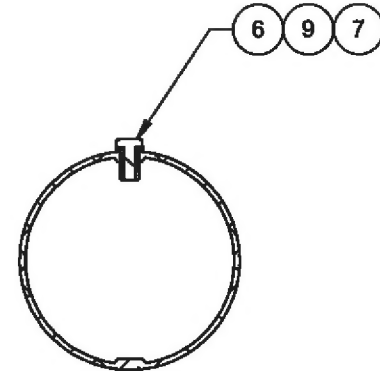
INSTALL D2973 SPACER AS FOLLOWS (2 PL)

1. CHAMFER HOLE 0.030X45 DEG
2. INSERT D2973 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. PASS  $\varnothing 0.625$  DRILL TO REMOVE SPILL OVER

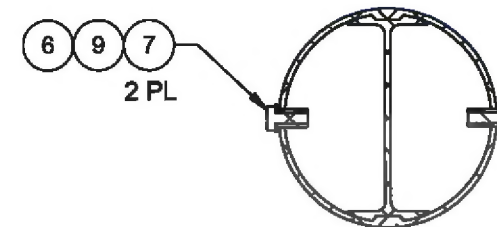


**DETAIL D**  
16 PL (BOTH SIDES)  
SCALE 4X

**D4680-043 SKIDTUBE SUB ASSY**



**SECTION E-E**  
SCALE 2.5X



**SECTION F-F**  
SCALE 2.5X

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: APPLY CHEMICAL CONVERSION COATING PER DART QSI 005 4.1 PRIOR TO INSTALLING D4681-041 WEB.  
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 17.91 lbs
- 8) SEAL ALL MATING SURFACES USING PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 9) INSERT D4681-041 WEB INTO D4680-1 SKIDTUBE IN LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX -241/-291 ADHESIVE PER DART QSI 015
- 10) INSTALL D4686-1 SPACER AFTER INSTALLING D4753-1 DOUBLERS
- 11) WELDING: PER QSI 004

APPROVED

DESIGN	AP	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	AP	KENT, WA	
CHECKED	DW	DRAWING NO.	REV. D
MFG. APPR.	JLM	D4680	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	SKIDTUBE	NTS
DATE	15.03.04	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

